

QUALITY ASSURANCE PROVISIONS

NSN: 9G 5365 - 01-220-4637 PQ

P/N: (77445) 2186272

NOMEN: FIRST STAGE TURBINE SEAL RING ASSEMBLY

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (77445) 2186272 Rev."C" or latest revision, and all details and specifications referenced therein.

I. Quality/Inspection Requirements

- A. MIL-I-45208 or ISO9000 equivalent applies:
- B. First Article Testing applies:
- C. Mandatory Inspection applies: Refer to contract section C.
- D. Production Lot Testing Applies

II. Supplemental Requirements

- A. Additionally, paragraph 3.1-3.5, 5.1-5.2, 6.1-6.2 of MIL-Q-9858 or ISO 9000 equivalent applies.
- B. The contractor shall identify on the process/operation sheets all manufacturing sources performing processes/operations outside of their facilities. These sheets shall not be revised or altered after the successful completion of First Article or
- C. Production Lot Testing without approval from the Engineering Support Activity (ESA), via the PCO.
- C. The Inspection Method Sheets that list the characteristics of each item produced under the contract shall have serial number tractability to the raw material, casting, or forging. In addition, the contractor is responsible for providing completed inspection method sheets showing the actual dimensions / measurements taken and the instrument used to take the dimension / measurement.
- D. Markings should be in accordance with MIL-STD-130 Rev. "J" paragraph 5.3.3(a), (b), (c), and (g). Method and location shall be in accordance with the drawing.

III. Mandatory Inspection Requirements

During production, mandatory inspection is required to be accomplished by the contractor, as follows:

A. Level of Inspection (LOI):

1) Critical Characteristics: 100% inspection shall apply.

2) Major and Minor Characteristics - LOI shall be in accordance with a sampling plan acceptable to the QAR.

B. Critical Characteristics, **DRAWING (77445) 2186272 REV. "C"**:

1) view "B" zone 13F

diameter 23.457 - 23.461

diameter 23.373 - 23.377

.945 - .955

2) Zone 10E / .197 - .201 / 22 LUGS EQ SP centered within .004

3) Zone 6F / 1.522 - 1.518

C. Major and Minor Characteristics:

1) Shall be defined by the contractor subject to QAR concurrence, unless defined on applicable drawings and associated specifications.

V. Unless expressly provided for elsewhere in this Clause, equipment such as fixtures, jigs, dies, patterns, templates, mylars, special tooling, test equipment, or any other manufacturing aid required for the manufacture and/or testing of the subject items will not be provided by the Government or any other source and is the sole responsibility of the contractor. The foregoing applies notwithstanding any reference to such equipment or the furnishing thereof that may be contained in any drawing.

FIRST ARTICLE TESTS REQUIRED / Production Lot (Contractor Testing)

I. First Article Inspection/Test Criteria

The tests to be performed under the First Article approval clause of the contract are:

A. Two (2) ea. Samples to be submitted for First Article Testing

B. Dimensional Check 100% of finished part, to ensure proper form.

D. Compliance with top drawing, (77445) 2186272 Rev. "C", subassembly drawings (77445) 2179496 Rev. "D", (77445) 2179497 Rev. "C" and specifications referenced therein.

D. Review documentation as provided under DD 1423 requirements.

In addition to the above tests, the First Articles to be delivered hereunder shall also be subjected to those tests that will demonstrate that the articles comply with contract requirements.

The contractor shall be responsible for providing necessary parts and repair of the First Article (s) during testing.

II. Testing Facility:

A. The testing/inspection shall be performed at the contractors facility by the contractor / witnessed by personnel from NAVICP Philadelphia / Tinker AFB DET Jacksonville. The QAR SHALL be present for all aspects of the dimensional and document inspection.

III. Notification of Testing: The contractor shall notify the PCO, ACO, and QAR, NAVICP and DET Jacksonville / Tinker AFB. prior to conducting First Article Tests so the Government may witness such testing.

A. The QAR, NAVY and Tinker AFB representatives shall be present to witness the First Article/Production Lot Inspection. .

IV. Test Report: The test report shall be in accordance with MIL-STD-831 and shall be submitted (2 copies) via the Cognizant CAO/QAR to the PCO. CAO/QAR shall provide comments on form DD 1222 (2 copies) which shall be forwarded with the test report. Approval of the test report is the PCO's responsibility. Upon notification of approval/conditional approval, the ACO shall execute the DD 250 to indicate Government acceptance of the test report.

V. Disposition of First Article Sample (s):

A. Samples may be considered as production items under the contract provided the samples can be refurbished to ready for issue (RFI) condition and provided the samples have inspection approval of the cognizant QAR. Samples may be shipped as production immediately upon acceptance of the FAT samples..

I-962 FIRST ARTICLE APPROVAL [CONTRACTOR TESTING]

A. The contractor shall notify NAVICP Philadelphia, and DSC Richmond within 15 days of the samples being ready for complete dimensional inspection. The inspection SHALL be performed at the contractors facility, by the contractor and witnessed by the QAR, NAVICP and Tinker AFB Personnel.
Notification shall be mailed to:

*Naval Inventory Control Point- Philadelphia
Attn.: Dan Ellis, Code 0733
700 Robbins Ave. Bldg. 2C
Philadelphia, PA 19111*

*OC-ALC/LPA-NAVY
Attention : Mr. Richard Robinson
3001 Staff Drive / STE 2 AG110
Tinker AFB, Oklahoma. 73145-3031*

B. Upon completion of the inspection at the contractors plant of the samples , a report shall be provided within 10 days. The contracting officer shall notify the contractor, in writing of the conditional approval, approval, disapproval of the First Article. The notice of the conditional approval or approval shall not relieve the contractor from complying with all requirements of the specifications and all other terms and conditions of this contract. A notice of conditional approval shall state any further action required of the contractor. A notice of disapproval shall cite reasons for disapproval.

C. If the First Article is disapproved, the contractor, upon Government request, shall submit an additional First Article for testing. After each request, the contractor shall make any necessary changes, modification, or repairs to the First Article or select another First Article for testing. All costs related to these tests are to be borne by the contractor, including any and all costs for additional tests following disapproval. The contractor shall furnish any additional First Article to the Government under the terms and conditions and within the time specified by the Government. The Government shall act of this First Article within the time limit specified in paragraph B above. The Government reserves the right to require an equitable adjustment of the contract price for any extension of the delivery schedule or for any additional costs to the Government related to these tests.

D. If the contractor fails to deliver any First Article on time, or the contracting officer disapproves any First Article, the contractor shall be deemed to have failed to make delivery within the meaning of the default clause of this contract.

E. Unless otherwise provided in the contract, and if the approved First Article is not consumed or destroyed in testing, the contractor may deliver the approved First Article as part of the contract quantity if it meets all contract requirements for acceptance.

F. If the Government does not act within the time specified in paragraph B or C above, the contracting officer shall, upon timely written request from the contractor, equitably adjust under the changes clause of this contract the delivery or performance dates and/or the contract price, and any other contractual term affected by the delay.

G. Before First Article approval, the acquisition of materials or components for, or the commencement of production of, the balance of the contract quantity is at the sole risk of the contractor. Before First Article approval, the costs thereof shall not be allocable to this contract for 1) progress payments, or 2) termination settlements if the contract is terminated for the convenience of the Government.

H. The contractor shall produce both the First Article and the production quantity at the same facility and shall submit a certification to this effect with each First Article.

PRODUCTION LOT TESTING REQUIREMENTS**[CONTRACTOR]****NSN: 9G 5365-01-220-4637 PQ****P/N: (77445) 2186272****NOMEN: FIRST STAGE TURBINE SEAL, RING ASSEMBLY**

The material produced under contract shall be accepted by the cognizant CAO/QAR upon the successful completion of these requirements.

I. Production Lot Test Requirements:

A. The cognizant CAO/QAR shall select two (2) item (s) for the Production Lot Test. In addition the QAR shall select item (s) at random from each successive lot or portion thereof

B. Production Lot Testing to be performed at the same time as First Article Testing and during production at the contractors facility witnessed and accepted by Tinker AFB/NAVICP Philadelphia. The QAR SHALL be present for this inspection.

C. Sample (s) are to be unpainted. Corrosive areas to be coated with a light preservative.

II. The tests to be performed under the Production Lot Sample testing provisions of the contract are:

A. Compliance with drawing (77445) 2186272 REV "C" or latest revision and all specification referenced therein.

B. Dimensional Check

In addition to the above tests, the Production Lot Sample(s) to be delivered hereunder shall also be subjected to those tests which will demonstrate that the sample(s) comply with contract requirements.

III. Testing location:

A. All testing will be accomplished at the contractors facility.

IV. NOTIFICATION OF TESTING:

The contractor shall notify the PCO, ACO, and QAR prior to conducting Production Lot Tests so the Government may witness such testing.

A. the QAR shall be present to witness all Production Lot Testing.

V. Shipment and Distribution of Samples

A. Sample(s) may be considered as production items under the contract provided sample(s) can be refurbished to ready For Issue (RFI) condition and provided sample(s) have inspection approval of the cognizant DCMAO. Sample(s) may be shipped as production items immediately.

C331 PRODUCTION LOT SAMPLE TESTING [CONTRACTOR TESTING]

A. The Production Lot Samples shall be selected at random by the cognizant government QAR. The samples shall be identified by contract number, lot number, and be clearly marked as follows:

***PRODUCTION LOT TEST SAMPLES
NOT R.F.I. MATERIAL
DO NOT TAKE UP IN STOCK***

B. Such samples shall be tested in sufficient time prior to the delivery of the production articles to allow a 15 day period for testing and written notification by the contracting officer of the approval or disapproval of the samples. Within 15 days of the receipt of the samples, the CAO shall notify the contracting officer, of the results of the testing, together with the recommendation for approval or disapproval.

C. In the event the contractor does not receive written notification of approval or disapproval of the samples for a particular lot within 60 days from their submission for such testing, the contract delivery schedule shall be equitably adjusted as necessary.

D. If the contractor fails to deliver any Production Lot Samples for testing within the time or times specified, or if the contracting officer disapproves any Production Lot Samples, the contractor shall be deemed to have failed to make delivery within the meaning of the default clause of this contract, and this contract shall be subject to termination for default.

E. In order for a Production Lot to be acceptable, all samples representative of the lot must pass all the contract requirements. In the event a sample fails to pass such requirements; the lot will be rejected. In such event, the government may, at its option and at no additional cost to the government, (I) terminate all or any portion of this contract for default, (II) require the manufacture of a new Production Lot, or a rework of the rejected Production Lot if the means and procedures by the contractor for rework are acceptable to the government, or (III) require the submission of additional samples for test. The foregoing procedures shall apply to new or reworked Production Lots in the same way as they did to the original Production Lot.

F. For each additional sample or each resubmission of a modified sample which the contractor is required to submit for approval hereunder as a result of a failure of a previous sample to conform to the requirements of the specification, the contractor shall pay to the government the costs of reinspection, examination and retesting the contractor and his sureties (if any) shall be liable for the amount of such costs.

G. Nothing contained in the foregoing provisions of this clause and no action of the government in accordance herewith, shall in any way prejudice the right of the government under the clause of this contract entitled Default.

CONTRACT DATA REQUIREMENTS LIST

(2 Data Items)

 FORM APPROVED
OMB NO. 0704-0188

PUBLIC REPORTING BURDEN FOR THIS COLLECTION OF INFORMATION IS ESTIMATED TO AVERAGE 440 HOURS PER RESPONSE, INCLUDING THE TIME FOR REVIEWING INSTRUCTIONS, SEARCHING EXISTING DATA SOURCES, GATHERING AND MAINTAINING THE DATA NEEDED AND COMPLETING AND REVIEWING THE COLLECTION OF INFORMATION. SEND COMMENTS REGARDING THIS BURDEN ESTIMATE OR ANY OTHER ASPECT OF THIS COLLECTION OF INFORMATION, INCLUDING SUGGESTIONS FOR REDUCING THIS BURDEN TO DEPT. OF DEFENSE, WASHINGTON HEADQUARTERS SERVICES, DIRECTORATE FOR INFORMATION OPERATIONS AND REPORTS, 1215 JEFFERSON DAVIS HWY., SUITE 1204, ARLINGTON, VA, 22202-4302, AND TO THE OFFICE OF MANAGEMENT AND BUDGET, PAPERWORK REDUCTION PROJECT (0704-0188), WASH. DC 20503. PLEASE DO NOT RETURN YOUR FORM TO EITHER OF THESE ADDRESSES. SEND COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT / PR NO. LISTED IN BLOCK 5.

A. CONTRACT LINE ITEM NO.		B. EXHIBIT		C. CATEGORY: TDP x TM OTHER									
D. SYSTEM/ITEM 9G 5365-01-220-4637 PQ TURBINE SEAL		E. CONTRACT/PR. NO.		F. CONTRACTOR									
1. DATA ITEM NO. 1		2. TITLE OF DATA ITEM CERTIFICATION DATA REPORT		3. SUBTITLE COMPLETE PROCESS OF SHEETS									
4. AUTHORITY (Data acquisition document No.) DI-MISC-80678/T1		5. CONTRACT REFERENCE		6. REQUIRING OFFICE NAVAL INVENTORY CONTROL POINT - PHILADELPHIA									
7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION SEE BLOCK #16	14. DISTRIBUTION									
8. APP CODE A		11. AS OF DATE AS REQ	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK #16	a. ADDRESSEE <table border="1"> <tr> <th colspan="2">b. COPIES</th> </tr> <tr> <th>Draft</th> <th>Final</th> </tr> <tr> <td></td> <td>Reg</td> </tr> <tr> <td></td> <td>Repro</td> </tr> </table>		b. COPIES		Draft	Final		Reg		Repro
b. COPIES													
Draft	Final												
	Reg												
	Repro												
16. REMARKS PARA. 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4, 10.2.5 SHALL APPLY * UPON SUBMISSION OF FIRST ARTICLE/ PRODUCTION LOT TEST SAMPLE (s) ** IF PROCESS OPERATION SHEETS CHANGE AFTER SUCCESSFUL COMPLETION OF FAT/PLT.				DCMA / ACO		*	1/0						
				DCMA / QAR		**	1/0						
				PCO / DSCR			1/0						
				NAVICP-P code 0733			1/0						
15. TOTAL					4/0								
1. DATA ITEM NO. 2		2. TITLE OF DATA ITEM CERTIFICATION DATA REPORT		3. SUBTITLE COMPLETE INSPECTION METHOD SHEETS									
4. AUTHORITY (Data acquisition document No.) DI-MISC-80678/T2		5. CONTRACT REFERENCE		6. REQUIRING OFFICE NAVAL INVENTORY CONTROL POINT - PHILADELPHIA									
7. DD 250 REQ LT	9. DIST STATEMENT REQUIRED	10. FREQUENCY AS REQ	12. DATE OF FIRST SUBMISSION SEE BLOCK #16	14. DISTRIBUTION									
8. APP CODE A		11. AS OF DATE AS REQ	13. DATE OF SUBSEQUENT SUBMISSION SEE BLOCK #16	a. ADDRESSEE <table border="1"> <tr> <th colspan="2">b. COPIES</th> </tr> <tr> <th>Draft</th> <th>Final</th> </tr> <tr> <td></td> <td>Reg</td> </tr> <tr> <td></td> <td>Repro</td> </tr> </table>		b. COPIES		Draft	Final		Reg		Repro
b. COPIES													
Draft	Final												
	Reg												
	Repro												
16. REMARKS PARA. 10.1, 10.2, 10.2.1, 10.2.2, 10.2.4, 10.5 SHALL APPLY * UPON SUBMISSION OF FIRST ARTICLE/ PRODUCTION LOT TEST SAMPLE (s) ** AT TIME OF CONTRACT COMPLETION.				DCMA / ACO		*	1/0						
				DCMA / QAR		**	1/0						
				PCO / DSCR			1/0						
				NAVICP-P code 0733			1/0						
15. TOTAL					4/0								
G. PREPARED BY Jesse B. Moody		H. DATE 13 OCT. 2000		I. APPROVED BY Robert Hughes									
				J. DATE 13 OCT. 2000									

CONTRACT DATA REQUIREMENTS LIST**(1 Data Item)****Form Approved****OMB No. 0704-0188**

Public reporting burden for this collection of information is estimated to average 110 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503. Please DO NOT RETURN your form to either of these addresses. Send completed form to the Government Issuing Contracting Officer of the Contract/PR No. listed in Block E.

A. CONTRACT LINE ITEM NO.**B. EXHIBIT****C. CATEGORY:**TDP X TM OTHER **D. SYSTEM/ITEM**

9G 5365-01-220-4637 PQ

E. CONTRACT/PR**F. CONTRACTOR**

TURBINE SEAL RING ASSEMBLY

1. DATA ITEM

2. TITLE OF DATA ITEM

3. SUBTITLE

5. CERTIFICATION DATA / REPORTS

4. AUTHORITY (Data)

DI-MISC-80678/T3

5. CONTRACT REFERENCE**6. REQUIRING OFFICE**

NAVAL INVENTORY CONTROL POINT - PHILADELPHIA

7. DD 250 REQ

LT

9. DIST

STATEMENT

10. FREQUENCY

AS REQ

12. DATE OF FIRST SUBMISSION

SEE BLOCK 16*

14. DISTRIBUTION**8. APP CODE**
A**11. AS OF DATE**

AS REQ

13. DATE IF SUBSEQUENT

SEE BLOCK 16*

a. ADDRESSEE**b. COPIES**

Draft

Final

Reg

Repro

PARA. 10.1,10.2,10.2.1,10.2.2,10.2.4,10.5 APPLY

BLOCK #12 -UPON SUBMITTAL OF FIRST ARTICLE SAMPLE (S) AND/OR PRODUCTION LOT SAMPLE.

BLOCK #3-SEPARATE REPORTS SHALL BE PROVIDED FOR THE BELOW LISTED SUB TITLES. CERTIFICATION REPORTS FOR PRIME PROCESS AND MATERIAL SPECIFICATIONS SHALL INCLUDE CERTIFICATION THAT ALL VENDORS PERFORMING THESE PROCESSES ARE PRIME (OEM) (99207) GENERAL ELECTRIC CO. APPROVED SOURCES.

BLOCK #5 - CONTRACT REFERENCE: P/N: (77445) 2186272 rev. "C"

1. FPI code 1 per QAD 2186272

2. Bond test per QAD 2186272

3. Braze per drawing note 1

4. Material certifications for sub-assemblies as noted on drawings 2179497 rev."C" and 2179496 rev. "D"

5. Sentencing per PWA drawing 2186272 note 9, QAD 2186272, VIS 353 and VIS 37

DCMA / ACO

DCMA / QAR

PCO / DSCR

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

1/0

G. PREPARED BY

Jesse B. Moody

H. DATE

13 OCT. 2000

I. APPROVED BY

Robert Hughes

J. DATE

13 OCT. 2000

17. PRICE GROUP

18. ESTIMATED TOTAL PRICE

INSTRUCTIONS FOR COMPLETING DD FORM 1423

(See DOD 5010.12-M for detailed instructions.)

FOR GOVERNMENT PERSONNEL

Item A. Self-explanatory.

Items B. Self-explanatory.

Item C. Mark (X) appropriate category: TDP - Technical Data Package; TM - Technical Manual; Other - other category of data, such as "Provisioning," "Configuration Management", etc.

Item D. Enter name of system/item being acquired that data will support.

Item E. Self-explanatory (to be filled in after contract award).

Item F. Self-explanatory (to be filled in after contract award).

Item G. Signature of preparer of CDRL.

Item H. Date CDRL was prepared.

Item I. Signature of CDRL approval authority.

Item J. Date CDRL was approved.

Item 1. See DoD FAR Supplement Subpart 4.71 for proper numbering.

Item 2. Enter title as it appears on data acquisition document cited in Item 4.

Item 3. Enter subtitle of data item for further definition of data item (optional entry).

Item 4. Enter Data Item Description (DID) number, military specification number, or military standard number listed in DoD 5010.12-L (AMSDL), or one-time DID number, that defines data content and format requirements.

Item 5. Enter reference to tasking in contract that generates requirement for the data item (e.g., Statement of Work paragraph number).

Item 6. Enter technical office responsible for ensuring adequacy of the data item.

Item 7. Specify requirement for inspection/acceptance of the data item by the Government.

Item 8. Specify requirement for approval of a draft before preparation of the final data item.

Item 9. For technical data, specify requirement for contractor to mark the appropriate distribution statement on the data (ref. DoDD 5230.24).

Item 10. Specify number of times data items are to be delivered.

Item 11. Specify as-of date of data item, when applicable.

Item 12. Specify when subsequent submittals are required, when applicable.

Item 13. Specify when subsequent submittals are required, when applicable.

Item 14. Enter addressees and number of draft/final copies to be delivered to each addressee. Explain reproducible copies in Item 16.

Item 15. Enter total number of draft/final copies to be delivered.

Item 16. Use for additional clarifying information for Items 1 through 15. Examples are: Tailoring of documents cited in Item 4; Clarification of submittal dates in Items 12 and 13; Explanation of reproducible copies in Item 14; Desired medium for delivery of the data item.

FOR THE CONTRACTOR

Item 17. Specify appropriate price group from one of the following groups of effort in developing estimated prices for each data item listed on the DD Form 1423.

a. Group I. Definition - Data which is not otherwise essential to the contractor's performance of the primary contracted effort (production, development, testing, and administration) but which is required by DD Form 1423.

Estimated Price - Costs to be included under Group I are those applicable to preparing and assembling the data item in conformance with Government requirements, and the administration and other expenses related to reproducing and delivering such data items to the Government.

b. Group II. Definition - Data which is essential to the performance of the primary contracted effort at the contractor is required to perform additional work to conform to Government requirements with regard to depth of content, format, frequency of submittal, preparation, control, or quality of the data item.

Estimated Price - Costs to be included under Group II are those incurred over and above the cost of the essential data item without conforming to Government requirements, and the administrative and other expenses related to reproducing and delivering such data item to the Government.

c. Group III. Definition - Data which the contractor must develop for his internal use in performance of the primary contracted effort and does not require any substantial change to conform to Government requirements with regard to depth of content, format, frequency of submittal, preparation, control, and quality of the data item.

Estimated Price - Costs to be included under Group III are the administrative and other expenses related to reproducing and delivering such data item to the Government.

d. Group IV. Definition - Data which is developed by the contractor as part of his normal operating procedures and his effort supplying these data to the Government is minimal.

Estimated Price - Group IV items should normally be shown on the DD Form 1423 at no cost.

Item 18. For each data item, enter an amount equal to that portion of the total price which is estimated to be attributable to the production or development for the Government of that item of data. These estimated data prices shall be developed only from those costs which will be incurred as a direct result of the requirement to supply the data, over and above those costs which would otherwise be incurred in performance of the contract if no data were required. The estimated data prices shall not include any amount for rights in data. The Government's right to use the data shall be governed by the pertinent provisions of the contract.